

Date: Wednesday, 07/01/2009 1:39:31 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BRACKET ASSEMBLY
<b>Job Number</b> : 44492	
<b>Estimate Number</b> : 10334	
<b>P.O. Number</b> :	<b>Part Number</b> : D2804042
<b>This Issue</b> : 07/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2804 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 44272	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 23/01/2009 <b>Qty:</b> 7 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JD 09.01.09</u>	
<b>Comment</b> : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM Est Rev:G As per Rev C 06-11-08 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D28042	Bracket
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

STA 155 Bracket

Pick:

Qty Part Number	Description	Batch
1 D2804-2	Bracket	41740

SS 09/01/12 (7)

2.0	D28052	Stop
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Stop

Pick:

Qty Part Number	Description	Batch
1 D2805-2	Stop	41707

SS 09/01/12 (7)

3.0	D2809	Bushing
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	39727

SS 09/01/12 (7)

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Press D2805-2 into arm as per Dwg D2804

CP 09/01/12 (7)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 07/01/2009 1:39:31 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 44492

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Scrub 12 (X2)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

7:30

OVEN TEMPERATURE:

320°

FINISH TIME:

8:00

FL 09/01/13

(7)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-13 (X2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press Fit D2809 as per Dwg D2804

09/01/12 (X2)

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 14.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

109147

SS 09/01/12 (X2)

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 14.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

2

MS21043-3 Nut

M109535

SS 09/01/12 (X2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 44492

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick:

Qty Part Number Description

Batch

4 NAS1515H3

Washer

A/R

LPS-3

Corrosion Spray

*wash the parts*

*SS 09/01/12*

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

*09/01/13 (7)*

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SB 09/01/13 (7)*

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*Pkg*

*MF 09-01-13*

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/01/13*

Job Completion



*MF 09-01-13*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

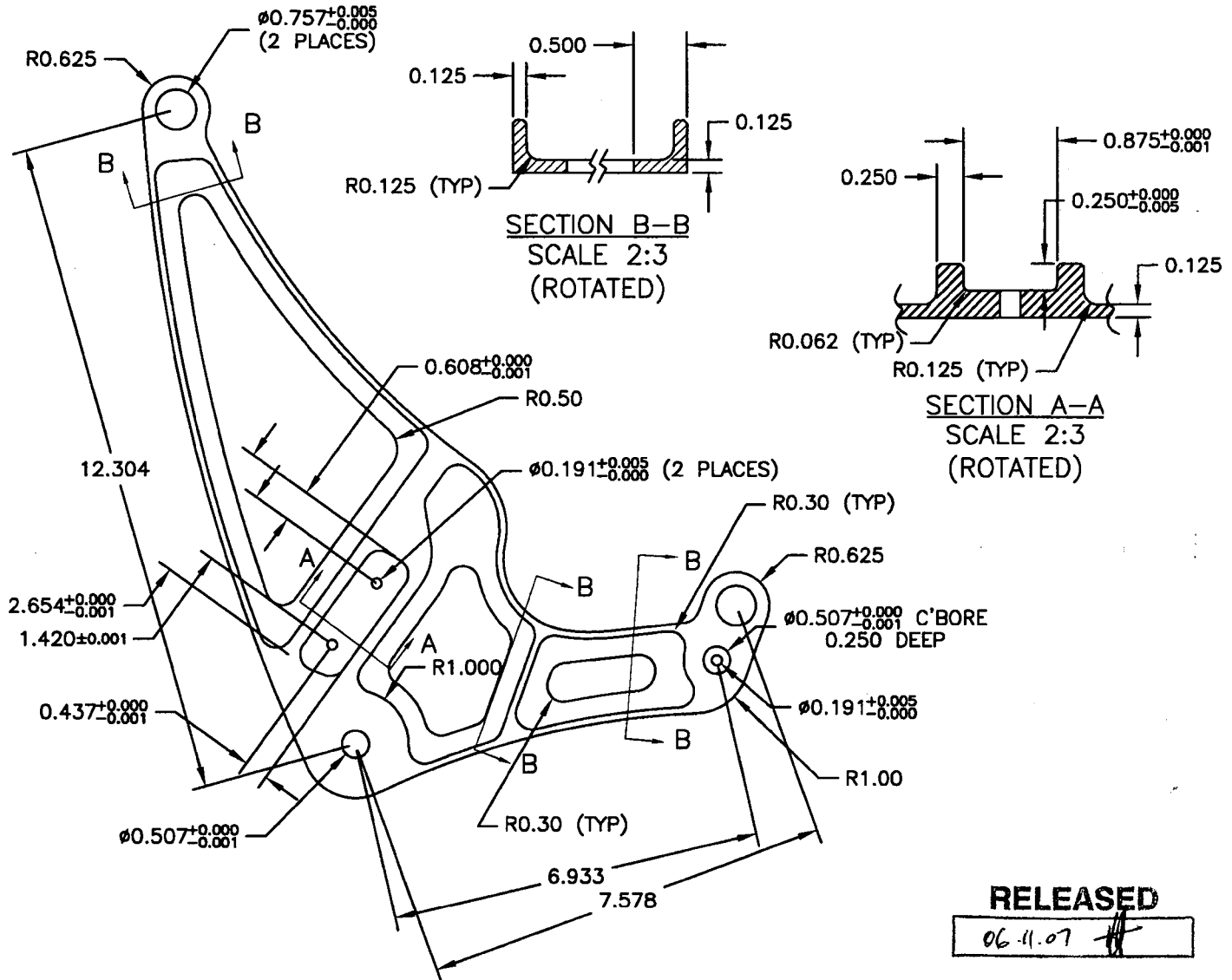
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**RELEASED**

06-11-07 #

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

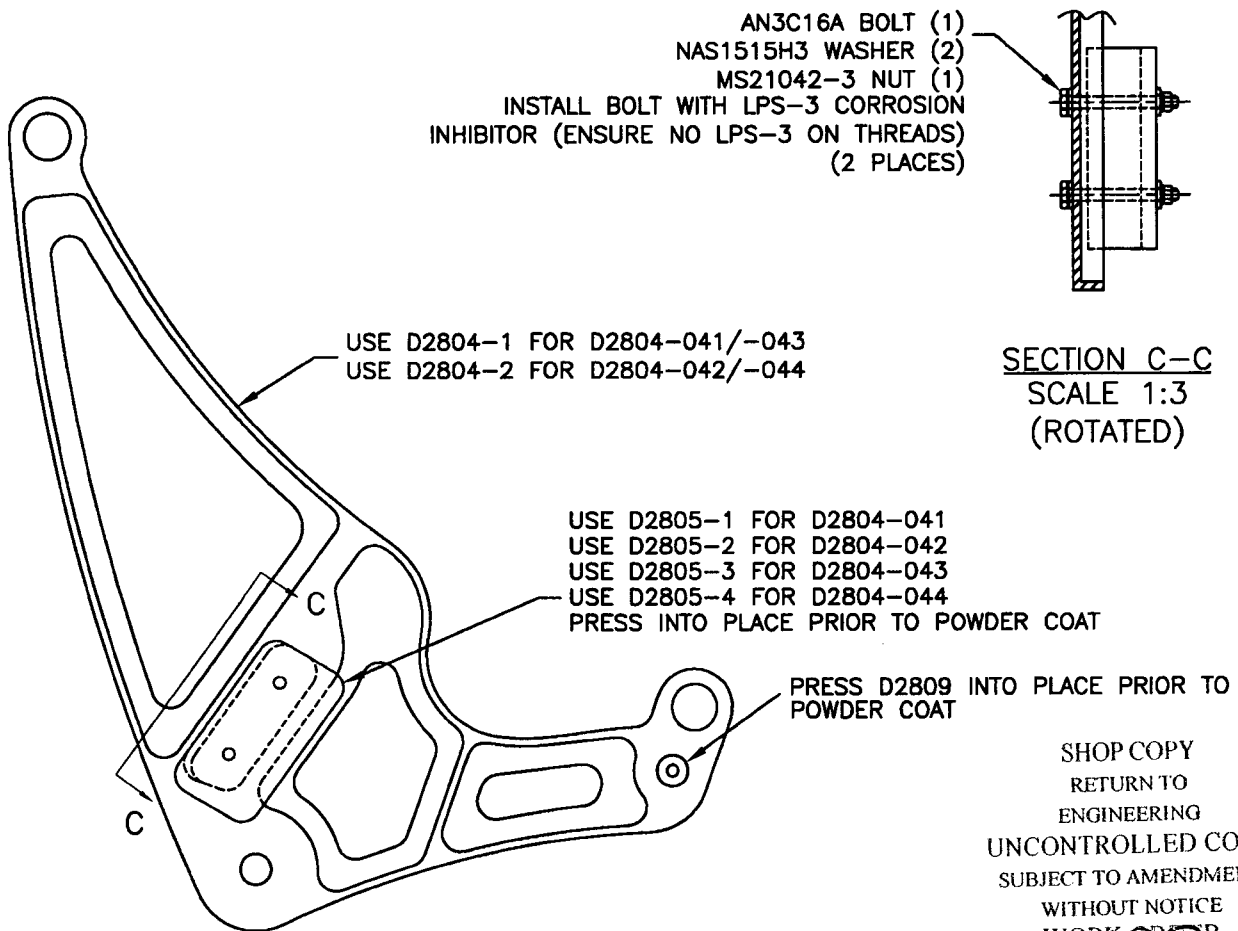
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WITHOUT NOTICE  
WORK ORDER  
NO. 44492

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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



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WORK ORDER  
NO. *14792*

**RELEASED**

*06.11.07* *[Signature]*

**D2804-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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